SPLIT -2

# Work Order ID 123614

*Monday, August 18, 2014 1:33:27 PM*

*123614*



**Item ID:** D3143-3 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Clevis

**Start Date:** 8/19/14 **Start Qty:** 25.00 *25* **Cust Item ID:**

**Required Date:** 8/29/14 **Req'd Qty:** 25.00 *25* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** M **Date:** 14-8-18 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Draw Nbr | Revision Nbr |
|---|---|
| D3143 | Rev B A |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | | 0.00 | | | | | | | |
| *100* | DOOSAN LATHE | | | | | 29 | Ø | | DAS 40 9-89 |
| Doosan | **Memo** | 0.00 | | | | | | | 14/08/20 |
| Doosan Lathe | 1-Turn as per Dwg D3143 and Folio F<br>Folio Rev: AA<br>Dwg Rev: A<br>2-Deburr | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | DAS 40 9-89 |
| *110* | | | | | | 29 | Ø | | |
| QC | **Memo** | 0.00 | | | | | | | 14/08/20 |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | DAS 08 9-89 |
| *120* | | | | | | 29 | Ø | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

D.a 14/08/20

# Work Order ID 123614

*Monday, August 18, 2014 1:33:27 PM*

*123614*

**Item ID:** D3143-3 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Clevis

**Start Date:** 8/19/14 **Start Qty:** 25.00 *25* **Cust Item ID:**
**Required Date:** 8/29/14 **Req'd Qty:** 25.00 *25* **Customer:**
**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | Identify as per dwg & Stock Location: STO21 | 0.00 | | | | 29X | DAS 28 9-89 | AUG 21 2014 | |
| *130* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | MCS | 14-08-21 | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-8-21

# Picklist Print

*Monday, August 18, 2014 1:33:33 PM*



**Work Order ID:** 123614

*123614*

**Parent Item:** D3143-3

*D3143-3*

**Parent Item Name:** Clevis

**Start Date:** 8/19/14 **Required Date:** 8/29/14

**Start Qty:** 25.00 **Required Qty:** 25.00

**Comments:** IPP REV:A 14.08.18 NEW ISSUE DD VERF:JFS

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M303R0.500 | | Purchased | No | | | | f | 50.8870 | | 4 | | | |
| *M303R0.500* | | | | | | | | | ** | | | 14/08/20 | DAS 40 9-89 |
| 303 Round Bar 0.500" | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code | | |
|---|---|---|---|---|
| MAT028 | 50.887 | | | |
| 125387 | 0.9033 | | | |
| M128496 | 1.7337 | | | |
| M129237 | 22.25 | | | |
| →M129666 | 26 | | 5.0 | TOTAL |

| DART AEROSPACE LTD | Work Order: | 123614 |
|---|---|---|
| | | |
| Description: CLEVIS | Part Number: | D3143-3 |
| | | |
| Inspection Dwg: D3143 Rev: A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø.440 | ±.010 | .440 | ✓ | | VERN | PAD-12 |
| .165 | ±.010 | .165 | ✓ | | VERN | PAD-12 |
| .065 | +.010 | .067 | ✓ | | " | " |
| .750 | ±.010 | .749 | ✓ | | " | " |
| 1.62 | ±.030 | 1.622 | ✓ | | " | " |
| .870 | ±.010 | 873 | ✓ | | " | " |
| | | | | | | |
| Ø.193 | +.005 -.001 | .193 | ✓ | | VERN | PAD-12 |
| .560 | ±.010 | .564 | ✓ | | " | " |
| | | | | | | |
| MOW | .2146 .2123 | .2130 | ✓ | | MIC | PAD-02 |
| Ø MAJ | .190 .184 | .188 | ✓ | | MIC | PAD-02 |
| | | | | | | |
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| Measured by: | DAS 40 9-89 |
|---|---|
| Date: | 14/08/20 |

| Audited by: | DAS 08 9-89 |
|---|---|
| Date: | 14/08/20 |

| Preliminary Approval: | |
|---|---|
| Date: | |

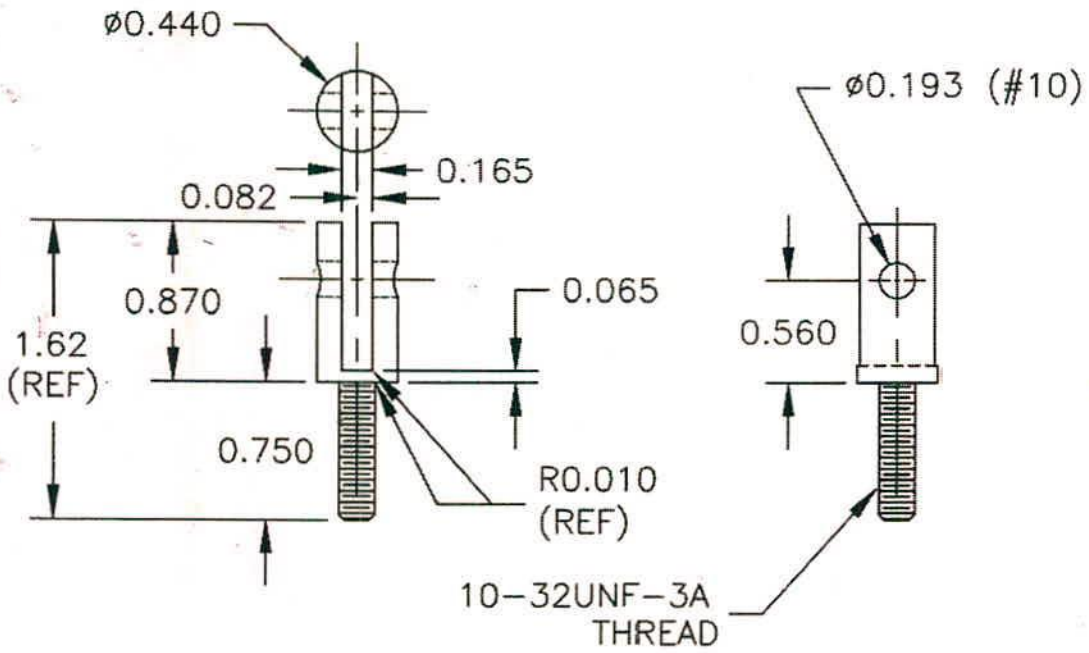
| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15

| | | | |
|---|---|---|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO.<br>D3143 | REV. A<br>SHEET 2 OF 2 |
| DATE<br>04.10.18 | | TITLE<br>CLEVIS | SCALE<br>1:1 |

QA COPY ISSUED

RELEASED
04.11.23




## D3143-3 CLEVIS

D3143-3 NOTES

1) MATERIAL: ANNEALED AISI 303 SS ROUND BAR (REF DART SPEC M303R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
5) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-179
6) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

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